

Date: Tuesday, 10/23/2007 3:11:37 PM  
User: Kim Johnston

# **Process Sheet**

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: OUTLET WELDMENT (206)
Job Number	: 35336		
Estimate Number	: 10473		
P.O. Number	: <i>N/A</i>	Part Number	: D2414
This Issue	: 10/23/2007 S.O. No. : <i>N/A</i>	Drawing Number	: D2414 REV. A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : LARGE FAB ASSY	Drawing Revision	: <i>N/A</i>
Previous Run	: 26906	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 11/6/2007
Checked & Approved By	: <i>[Signature]</i>	Qty:	3 Um: Each
Comment	: Est: C 03.04.14 Reformat; Incorporated D2292; D2375-3-08-106; D2403 - D2417 KJ/RF		

## **Additional Product**

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2292	Heater Tube 4"
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)  
Heater Tube 4"

Qty	Part Number	Description
1	D2292	4" Ring

Batch

*B35339 -> 1*  
*B30600 -> 2*

*PD 07-10-25*

2.0	D2406	3" Heater Tube
-----	-------	----------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)  
3" Heater Tube

Qty	Part Number	Description
1	D2406	3" Tubing

Batch

*B27134*

*PD 07-10-25*

3.0	D2415	End Plate
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)  
End Plate

Qty	Part Number	Description
1	D2415	End Plate

Batch

*B26913*

*PD 07-10-25*

4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1  
Weld D2414 Outlet Assembly as per Dwg D2414 and QSI 004.

*PD 07-10-25(3)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 01/12/16  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/23/2007 3:11:37 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: OUTLET WELDMENT (206)

Job Number: 35336

Part Number: D2414

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

10/10/29 (3)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FD 01/10/29 (3)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT ALODINE

counter  
10/10/29 (x3)

8.0

OUTSIDE SERV.15

OUTSIDE SERVICES - LF



Comment: Sub-Contracting OUTSIDE SERVICES

Issue P/O: 4957

Red Anodize D2414 as per Dwg D2414

Possible Supplier: Anodizing TNM Paint

Ensure Certificate of Conformity is attached

CL0714101 (3)

11/10/29 (3X) SP

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

7-11-02 SCL (3X)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7-11-13 (3)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 169

7-11-15 SP 3X

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

10/11/16 (3)

Job Completion



10/11/16

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



PREPARED B. Williams		DART AERO ACCESSORIES INC VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED BW	APPROVED BW	D2414	REV. A SHEET 1 OF 2
DATE Apr. 6, 1995		TITLE 206 OUTLET WELDMENT SCALE	

RELEASED  
96/09/10 BW

QTY	Part No.	Description
X	D2414	OUTLET WELDMENT ASSEMBLY
1	D2292	4" TUBING
1	D2406	3" TUBING
1	D2415	END PLATE

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 35336

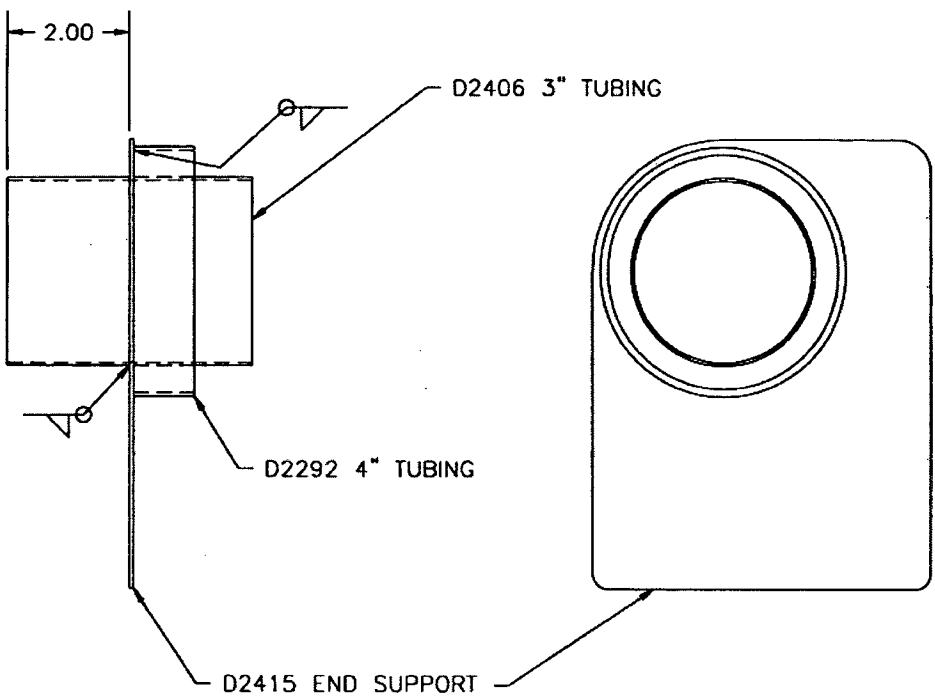
**DART**



PREPARED	DART AERO ACCESSORIES INC		
B. Williams	VICTORIA INTERNATIONAL AIRPORT, CANADA		
CHECKED	APPROVED		REV. A
BWS	BWS	D2414	SHEET 2 OF 2
DATE		TITLE	SCALE
Apr. 6, 1995		206 OUTLET WELDMENT	

**RELEASED**

9609/0 BWS



FINISH: ANODIZE

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 35336

TNM.

# ANODISATION et PEINTURE TNM INC.

C. OF C

21 chemin de l'Aviation, Pointe Claire QC H9R 4Z2

Telephone: (514) 429-7777 Fax: (514) 429-5108

Certifié ISO 9001-2000 / AS9100 certified

approuvé NADCAP approved

59970

09-Nov-2007

CLIENT / CUSTOMER:

DART AEROSPACE LTD.

1270 ABERDEEN STREET

HAWKESBURY, ONTARIO

K6A 1K7

CERTIFICATE OF COMPLIANCE  
CERTIFICAT DE CONFORMITE

PURCHASE ORDER/  
NO. DE COMMANDE:

04957



ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER & DESCRIPTION	PART PROCESS & TREATMENT
1	4	4	D2413B35335	RED ANODIZE PER MIL-A-8625F TYPE II CLASS 2 ALL OVER
3	3	3	D2414B35336	RED ANODIZE PER MIL-A-8625F TYPE II CLASS 2 ALL OVER
1	2	2	D2224B34970	RED ANODIZE PER MIL-A-8625F TYPE II CLASS 2 ALL OVER

Nous certifions que les pièces énumérées ont été traitées, testées et inspectées selon les spécifications mentionnées.

Les cartes de travail ont été remplies et sont disponibles pour consultation, sur demande.

All parts are processed, tested, and inspected to the requirements of above specifications.

Travel cards have been filled and are available for viewing upon request.

NOTE: Painted Parts will be Fully Solvent Resistant after 7 (seven) Full Days of Air Curing at Ambient Temperatures"

NOTE: Les pièces peintes seront complètement résistantes au solvant après 7 (sept) jours complets de séchage à l'air ambiant.

Signature/Signed:

*[Handwritten signature]*  
13

ENT / CUSTOMER:

PURCHASE ORDER / 04957  
NO. DE COMMANDE:

RT AEROSPACE LTD.

0 ABERDEEN STREET  
WILKESBURY, ONTARIO

A 1K7

CONDITIONS / TERMS:

NET 30 JOURS / NET 30 DAYS

ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER & DESCRIPTION	PRIX UNITAIRE UNIT PRICE	EXTENSION
1	4	4	D2413B35335	\$0.00	\$0.00
3	3	3	D2414B35336	\$0.00	\$0.00
1	2	2	D2224B34970	\$0.00	\$0.00
			MINIMUM CHARGE		\$120.00
				SUB TOTAL:	\$120.00
				TPS/GST:	\$7.20
				TVQ/PST:	\$0.00
				TOTAL AMOUNT DUE:	\$127.20

No de TPS / GST #: 891559734 RT

No de TVQ / QST #: 1019307154 TQ000

CERTIFICAT DE CONFIRMITE EMIS POUR CHAQUE PROCEDURE

CERTIFICATE OF COMPLIANCE ISSUED FOR EACH PROCESS

En cas de perte ou de dommages dû a la la valeur intrinsèque de certaines responsabilité se limitera à deux fois la valeur du  
traitement des pièces perdues ou endommagées.

Due to the intrinsic value of some parts, we are only liable for loss or damage to twice the invoiced finishing costs.



**21 chemin de l'Aviation, Pointe-Claire, QC H9R 4Z2**  
**Telephone: (514) 429-7777 Fax: (514) 429-5108**  
**Certifié ISO 9001-2000 / ISO 9001-2000 certified**  
**Certifié NADCAP / NADCAP certified**

**PACKING  
SLIP**

**59970**

**09-Nov-2007**

**CLIENT / CUSTOMER:**

**DART AEROSPACE LTD.**

**1270 ABERDEEN STREET**

**HAWKESBURY , ONTARIO**

**K6A 1K7**

**PURCHASE ORDER/  
NO. DE COMMANDE:**

**04957**

ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER & DESCRIPTION
1	2	2	D2224B34970
1	4	4	D2413B35335
3	3	3	D2414B35336

**PICKED UP BY / RECU:** \_\_\_\_\_

*En cas de perte ou de dommages dû a la la valeur intrinsèque de certaines responsabilit  se limitera   deux fois la  
valeur du traitement des pieces perdues ou endommag es.  
Due to the intrinsic value of some parts, we are only liable for loss or damage to twice the invoiced finishing costs.*